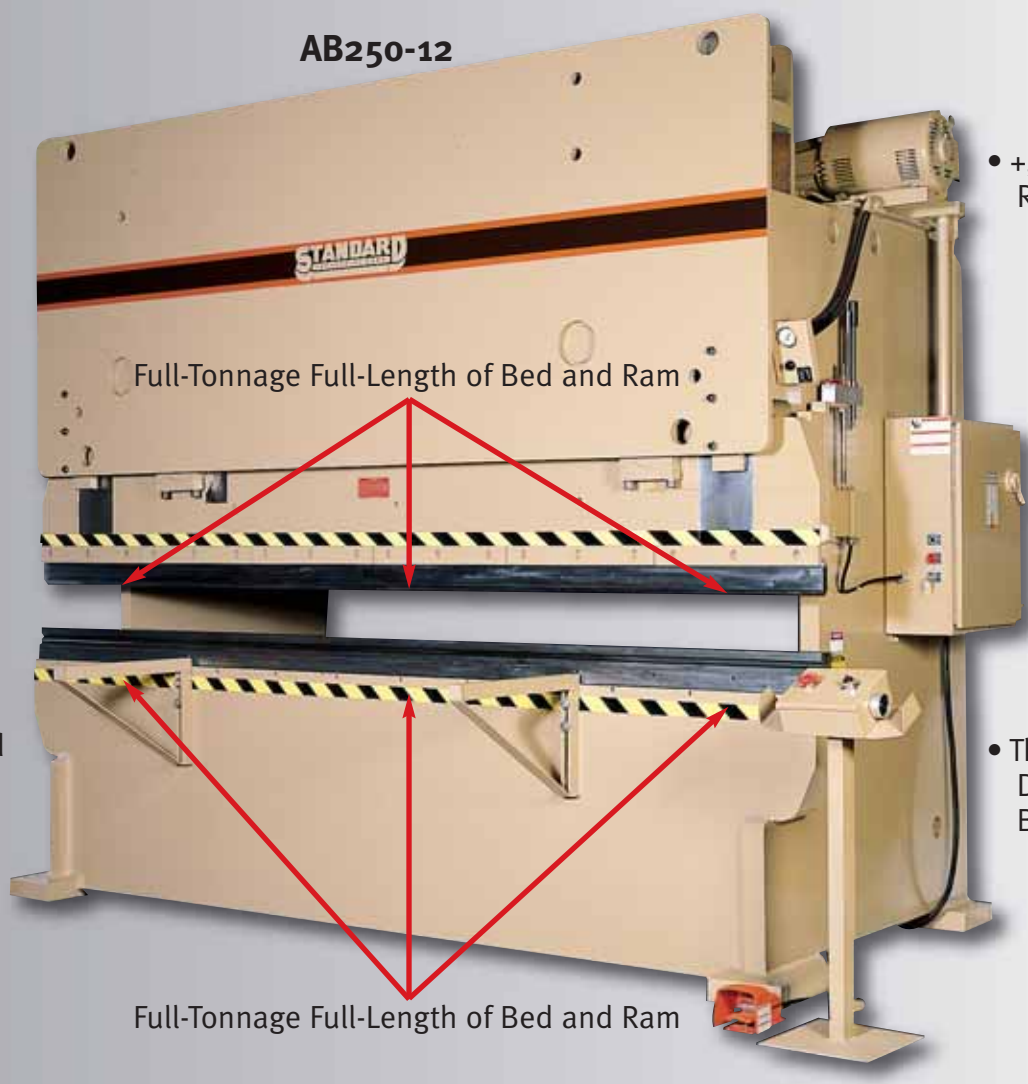
FORMING

Why It Is Important For You To Buy A Standard Industrial Press Brake

- Standard Industrial is 100% Owned, Operated and Manufactured In The U.S.A.
- 5 Year Across The Board Parts and Limited Labor Warranty
- Unheard of Factory and Dealer Service and Support

AB250-12

- Full-Tonnage Throughout Stroke
- Typical 30+ Year Lifetime, Plus a Lifetime of Parts and Service Availability
- Solid, Non-Moveable Lower Beam Substantially More Rigid Than “Bed Level” press Brakes



- +,- .001" Ram Repeatability
- Off-center loading Capability
- The Most Heavy Duty Press Brake Built In The U.S.A.

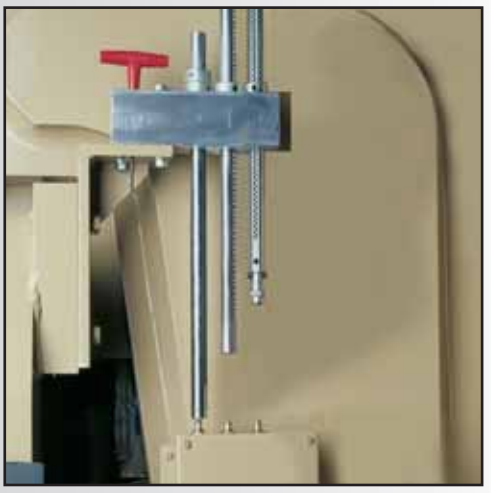
- Extremely Heavy-Duty lower beams allowing the least amount of deflection. Less Deflection = Longer Tool Life = More Profitability.

- Groove in bed for tooling is standard on all brakes.

- All Components are readily available from your local suppliers and are covered by our 5 year warranty

- All parts will be readily available for a lifetime from anywhere in the U.S.A.

- Precision mechanical in-line depth stop as back-up for any CNC control



- The in-line depth stop insures NO Down-Time due to computer failure.

Quality Assured

- Simple and Precise Ram level Indicator

- Always visible, easy to read

- Simple and Precise Ram Level Adjustment

- Infinite ram to bed level adjustment of +,- 1/8" from centerline

- Newly designed compact rams with minimal overhang

- Provides full forming ability

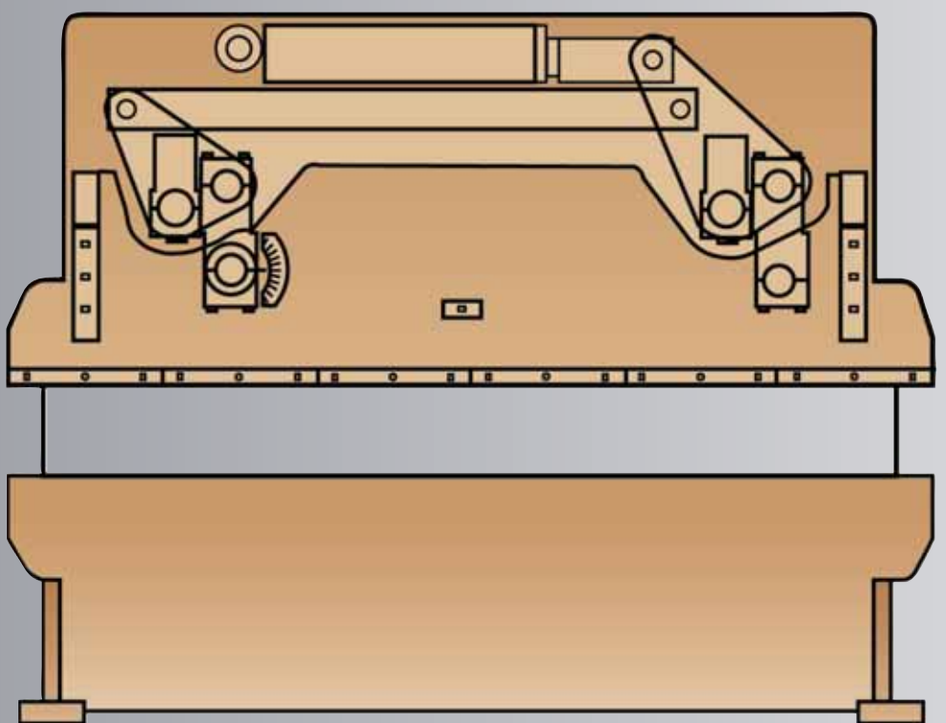
Single Cylinder Hydra-Mechanical Drive System

- Each A660 bronze bearing is guaranteed for 5 Years
- Our exclusive 1 Cylinder design means no balancing act like 2 cylinder systems with uneven tonnage.
- Each bearing is designed to withstand 6 Times Total Tonnage of brake
- Full tonnage throughout stroke and full tonnage the entire length of the bed and ram

New Manifold Based Hydraulic System

- Incredibly Simple To Troubleshoot
- All Parts Available To You locally
- Exceptional Ram Speeds For Fastest Strokes Per Minute
- 5 Year Parts Coverage
- Fewer Hoses, Tubing, Fittings Provides Far LESS Maintenance And Downtime
- Located overhead to provide clear operator area

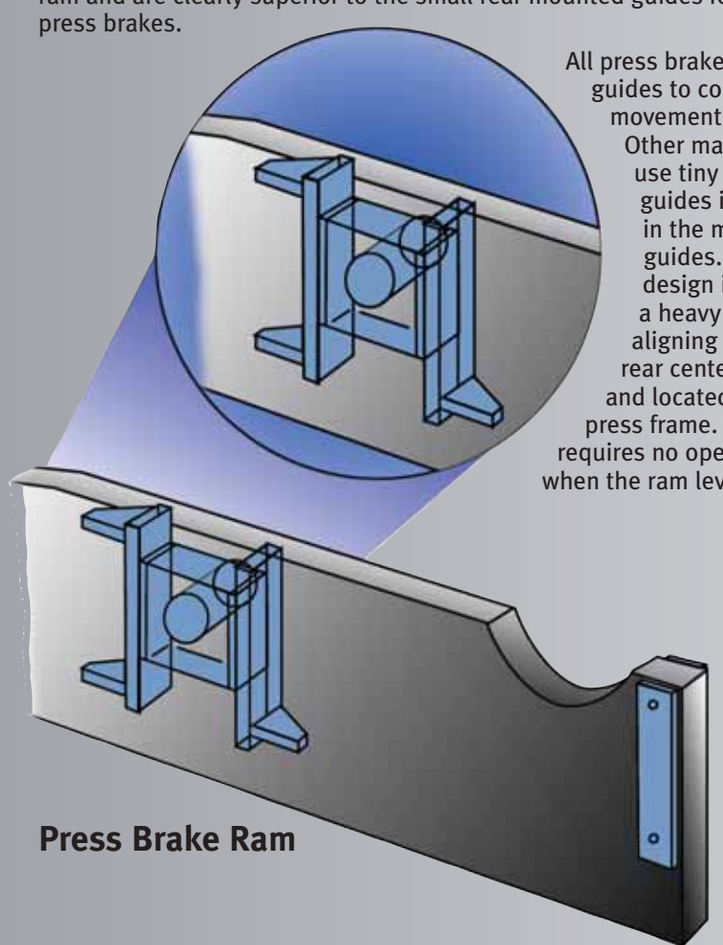
100% Owned, Operated and Manufactured In The U.S.A.



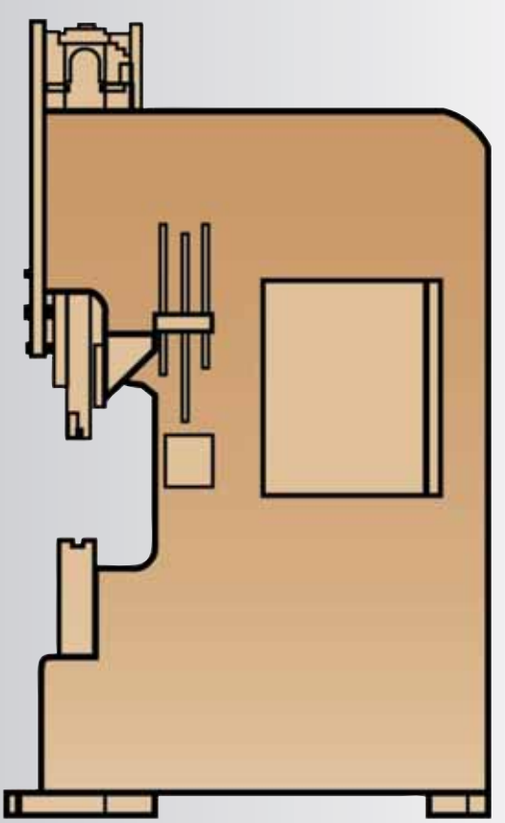
The hydraulic/mechanical system as used by Standard is certainly a superior concept as evident by the number of manufacturers currently offering similar products. However, we have more experience in years and thousands of products designed and manufactured than any in the business. Our design experience is reflected in our size and type of bearings and shafts as well as our technical capability to design a bellcrank system that does not have excessive side loads. All forces are vertical above the ram centerline and are contained in the "box" structure that houses the drive system and ram guides.

The ram of the press brake is guided by heavy duty slides as used in straight side presses. These slides are located both front and back of each end of the ram and are clearly superior to the small rear mounted guides found on other press brakes.

All press brakes require guides to contain end movement of the ram. Other manufacturers use tiny segmented guides incorporated in the main ram guides. The Standard design is to provide a heavy duty, self aligning system at the rear center of the ram and located inside the press frame. This system requires no operator action when the ram level is adjusted.



Press Brake Ram



Start With The Best Foundation Possible ... And Build From There

Over the past 35 years we have overwhelmed our customers and our competition by the uncompromising rigidity of our machinery. This rigidity coupled with our simplicity and trouble free operation has made us one of the top selling press brake manufacturers in the world. In January of 2000 we initiated an unheard of 5 year parts and limited labor warranty that drastically separated us from our competition and we haven't stopped there. Our newly developed press brake ram and hydraulic systems have separated Standard Industrial even more from the other brake manufacturers.

Too many manufacturers today base their machines productivity on computerized technology rather than the quality of the brake itself. We here at Standard Industrial start with a solid well designed 100% U. S. made machine and then add the merits of CNC capability to provide you with the best machine on the market today.

- ***Most well built, heaviest brake on the market***
- ***Least amount of Deflection on any brake available***
- ***All parts covered for 5 years and afterwards a lifetime supply of available parts from your local vendors***

AB100-10

With full tonnage throughout the stroke and more importantly throughout the entire length of the bed and ram the Standard Industrial brake has a repeatability advantage over most dual cylinder brakes. Direct dual cylinder brakes require complicated hydraulic and electrical systems to balance their tonnage and they require a vast amount of labor and parts as the machines age. Typically the customer is forced to pay exorbitant prices for the parts and labor that they can only get from that manufacturer. We at Standard pride ourselves on the fact that customers can get parts for their brake from their local suppliers and the simplicity of the equipment requires only the most basic trouble shooting.

Another version of the dual cylinder machine is the torque tube brake that has two cylinders generating about 1/2 of the machines overall tonnage. Torque tube brakes do not generate full tonnage across the bed, they essentially only develop full tonnage in the center of the brake bed. The torque tube pulls tonnage from each cylinder which can cause distortion with off-center loading or full length bends.

When you have a Standard Industrial single cylinder brake there is no balancing act between cylinders and there are no expensive, complex hydraulic systems compensating for each cylinders weakness. One cylinder means full tonnage everywhere on the brake therefore you can achieve a ram repeat accuracy of +/-.001" no matter where you do your work.

When you start with the solidly built Standard Industrial machine, you know you have the best foundation possible and you build from there.

Our brakes were specifically designed for the following applications:

- Full length bends where full tonnage across the bed is a necessity for the truest bends
- Off-center loading when any amount of the brakes tonnage is needed across the bed
- Center loading where any amount of the brakes tonnage is required
- Multiple die set-ups across the bed that require varying amounts of tonnage
- Punching applications in one area or at varied locations across the bed – each brake has a counter balance valve to allow the least shock to the hydraulic system
- Short piece work, with some of the fastest ram speeds on any brake, your small piece work is done quickly, easily and with precision.

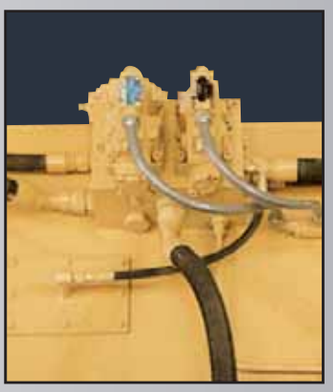
AB325-12

- Any Size Facility will benefit for the Standard Industrial brake from the price conscious smaller facility that does piece by piece work up to the 3 shifts a day high production manufacturers that require dependable, low maintenance machines with readily available components for minimal downtime

Standard Features On All Press Brakes

- (2) 24" heavy duty support arms for gauging& easier part handling

- Hydraulic pressure tonnage control to easily vary tonnage



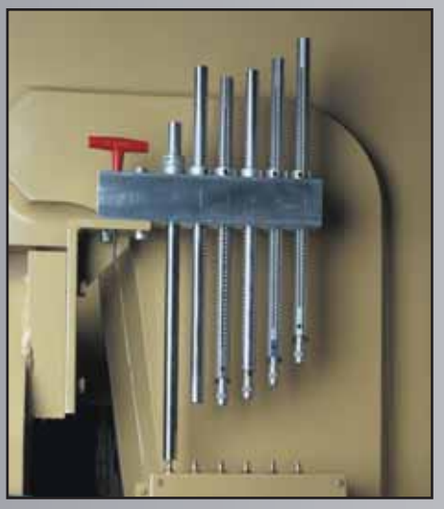
- Manifold hydraulic system for trouble free maintenance

- Spring loaded clamps for easy, quick die change

- 5 Year warranty on all parts & limited labor—The best warranty available today
- Easy to read mechanical ram level indicator and simple, precise ram level adjustment
- Counterbalance valve for punching and blanking to provide minimum shock
- Mechanical in-line depth stop to set the top limit, the speed change and a micrometer adjustable lower limit for the most precision bends
- All parts are readily available from your local suppliers-off the shelf parts for a lifetime
- All parts are listed in the press brake manual with detailed drawings and the original manufacturers part number so you can always find parts for your press brake
- Hydraulic reservoir with oil filter—Oil is not included
- Electric disconnect switch with magnetic starter—Simply run your power to the box
- Full tonnage the entire length of the bed and ram

Portable 2 Hand Pedestal Control

- Full tonnage throughout the stroke—Full tonnage is developed anywhere in slow speed
- Both ends of ram tapped to accept your four way die lifters
- Incredibly simple and versatile hydraulic and electric controls
- Spring loaded die clamps for easy, quick die change
- Ram readily accepts standard or safety tang dies—Can optionally be fitted to accept European tooling
- Positive single cylinder hydra-mechanical drive system
- Electric anti-whip control for your operators safety
- Overload protection to avoid damaging the press brake
- Shock-less, quite operation
- Fully adjustable stroke, open height and speed change
- Extremely heavy duty, rigid, all steel unitized frame
- Lube fittings at all bearing points
- All liquid tight electrical components
- (2) 24" support/gauging arms
- Hydraulic pressure tonnage control with gauge
- Die groove in bed with set screws in front and rear of brake bed
- Portable 2 hand control station with normal-inch (jog) modes, E-stop and palm buttons
- All Standard Industrial press brakes are stringently designed to meet O.S.H.A and ANSI B11.3 standards as well come complete with J.I.C. type and U.L. listed electrical components



- 4 Position In-Line Depth Stop with micrometer adjustable limits with pedestal mounted selector switch

- Automatic Lubrication allowing the least amount of maintenance

- Wide Flange Beds Permanent or removable allowing a wide variety of work

OPTIONAL FEATURES

Ram Control and Safety Systems

Hand/Foot Safety Sequence With Footswitch – System that allows the operator to use a footswitch after the ram hits the slow speed.
Light Curtain Safety Barrier With Footswitch – Infrared light system that allows the use of a footswitch during all points of operation.
Extra 2 Hand Control Station – Extra 2 hand pedestal station for 2 man control (one pedestal is standard).
Extra Footswitch – For 2 man control in use with Hand/foot sequence or light curtain system.
Low Speed Retract – Slows the return speed of the ram down considerably when handling heavy, long work pieces, recommended for large press brakes – Can be turned on/off for small work.
4 Position In-Line Depth Stop – Pre-set up to 4 different ram depths with micrometer precision and select all four ram depths from 4 position selector switch mounted on pedestal.
Auto Return Of Ram – Ram automatically returns to top of stroke after completion of stroke.
Adjustable Pressure Sensitive Ram Reversal – Protect dies and work-pieces by setting a maximum pressure and once the pressure is achieved, the ram reverses.
Programmable Ram Control –Set the Up limit, Speed change, the Lower limit and many other features with a PLC (Y axis) control.

Lube Systems

Manifold Centralized Lube System – All lube points are brought to a centralized location on the back of the brake for incredibly simple and fast maintenance.
Automatic Lubrication System – All points are automatically lubricated with a powered pump through an air operated, timed system.

Bed And Ram Extensions

10" Wide x 10' Long Removable Flanges For Bed And/Or Ram – 10" wide precision machined, removable bed and/or ram extensions x 10' in length between the end frames (NOTE) Must be ordered with machining of bed and ram for flanges.
Machining For 10" Wide x 10' Long Removable Flanges – Precision machining to the bed and/or ram required to mount the machined flanges.
Permanent Bed And Ram Flanges – Non-removable, permanent flanges for bed and/or ram used for wide dies and pressing applications (NOTE) Typical press brake tooling cannot be used w/ wide bed and ram.
Horns For Bed And Ram – 12" long extensions of the bed and ram designed to lengthen the bed and ram but not the distance between housings.

Other Available Options

Decompression System For Bottoming Applications – Reduces shock to hydraulic system that occurs during bottoming applications.
Die Roll Bars For Four Way Dies – Convenient hooks in the ram that aid in turning four way dies.
24" T-Slot Support/Gauging Arms – Heavy duty T-slotted arms that provide support for work pieces and allow operators to set stops in t-slots for gauging purposes. Also available with scales.
Drop Stops For T-Slot Support Arms – Gravity stops that allow operators to easily gauge material.
5/8" T-slot Across Front Edge Of Brake Bed – T-slot across edge of bed to move arms left to right.
Extra Open Height – Increases the open height of ram (NOTE) Does not increase stroke length.
Extra Stroke – Increases overall ram stroke (NOTE) Does not increase open height.
Extra Throat Depth – Increases overall throat depth measured from the centerline of bed.

Optional Controls and Gauging

All gauges offered by Standard Industrial are made in the U.S.A. with readily available components

Front Operated, X Axis Only, PLC Controlled Power Backgauge

Extremely heavy duty, front operated X axis only backgauge with 30" of travel and multi-level X axis programmability. Just like a CNC, the X axis will automatically actuate to the next depth after a programmed amount of strokes are achieved. Also includes simple GO-TO ability, Inch/Metric conversion, job stacking, +,- keys for minute changes, manager controlled password protection and Siemens touchscreen display (2 year warranty on PLC).

1, 2 or 3 Axis (X, Y, and R) CNC Controls – 100% U.S. Made

Automec CNC300

- 300 job programmability
- Automatic calibration to tool height
- RS232 download port
- alpha-numeric part numbers
- Angle adjust for angle correction
- 11 digit job number

Automec CNC2000

- 10,000 job storage
- Floppy disk drive
- Full color 9.5" display
- Angle or ram depth programming
- Pop Up "Windows"

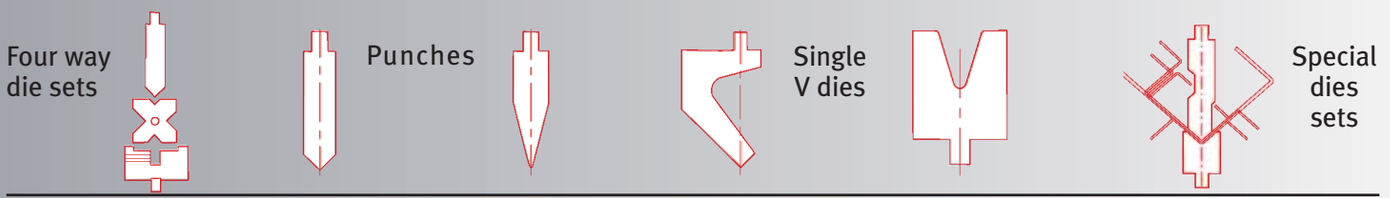
All Automec Gauges Are Equipped With The Following

- Single entry Ram offset & Bend allowance
- Inch/Millimeter conversion
- Backgauge reversal on pinch point
- Teach Mode
- Up to 48" travel (24" is standard)
- Off-line programming
- Tooling Library
- Parts Counter
- Help screens
- 1, 2 and 3 axis capability
- Incredibly Quick and Simple job set-up
- 2 Year Parts Warranty

NOTE: CNC BACKGAUGES ARE NOT SUBJECT TO STANDARD INDUSTRIAL 5 YEAR WARRANTY

Standard Industrial also offers Hurco CNC controls, gauges and tooling accessories

American Four Way and Single Vee Dies



CROWNING SYSTEMS, TOOLING AND ACCESSORIES

Manual Crowning System

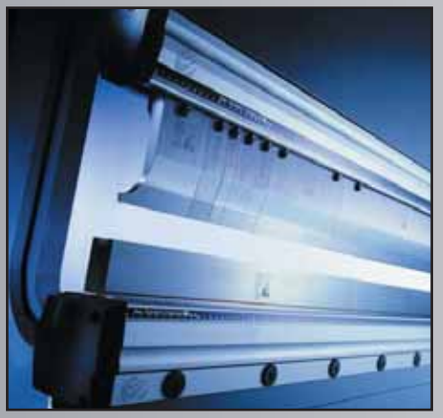
- Central dial adjusts from 0 to .100" in seconds
- Adjustment dials every 8" that give crown at that point of the bed up to .017" for small variances in bed and worn tooling
- Optional clamps for 4 way dies

Manual Crowning System with Hand Crank and Reader

- Hand crank w/reader for precision adjustment in seconds • Automatically adjusts for brake deflection proportionally over full length of bed
- Adjustment screws every 8" for fine adjustment
- Built in clamping bars which automatically center and align single V-dies in seconds

We also offer:

Hydraulic and Manual Quick Change Ram Clamps • European Style Tooling
Sectionalized Tooling • Adjustable bottom tools • Manual and CNC Controlled Crowning Systems



Segmented New Standard and American Precision Ground Tooling

Push-Button Quick Change Tooling Systems

- Safety-Click button to snap tools in & out vertically in seconds
- Punches are automatically clamped, seated & aligned with one button
- Both tooling & clamping are precision ground to +/-.0004"
- Available with hydraulic & mechanical clamping for 5 to 10 times faster set-up than conventional tooling

American Precision Ground Tooling

- Designed to fit conventional American nose
- Segmented to allow for any length bending
- Tooling is precision ground to +/-.0004" & hardened at wear points to Rockwell 60C.
- Punches & dies available for air and bottom bending
- Above shown with precision lower tool holder to align single v-tools automatically

5 YEAR WARRANTY

The Standard Industrial Corporation Five Year Warranty

As part of the purchase of a new Standard Industrial machine, a 5 year limited warranty will be included. The warranty begins at the point of initial shipment and will not automatically be passed along to second owners. The decision to repair or replace any part will be made by Standard Industrial management only. On all simple warranty repairs, Standard Industrial will provide instruction and parts (fob Clarksdale, MS). The customer or dealer involved will be invoiced for any replaced components and credit will be issued upon return of the defective component to Standard Industrial Corp.

The Five Year Warranty Covers The Following: Main hydraulic cylinder and seals • Drive components • Shafts • Bearings • Motors • Pumps • Valves • Backgauge components manufactured by Standard Industrial (not PLC components) • Structural integrity of non-removable parts of the machine • Hold down cylinders and seals • Fittings

Labor: Labor to repair structural integrity problems (cracks in the frame) of non-removable parts which fail during the 5 year warranty may be furnished at the customers plant in the continental U.S. This labor is supplied at no charge only if Standard Industrial is in agreement that the problem is not due to improper use of the machine or wrongful tampering with the machine by customer or dealer. Labor to assist our service rep. and/or necessary services are to be furnished by the customer at no cost to Standard Industrial. Labor to repair removable components (anything other than the welded frame of the machine) will only be supplied if the customer sends the failed component(s) back to Standard Industrial freight pre-paid to be repaired at our facility. The repaired components will be shipped back to customer (fob Clarksdale, MS). **Standard Industrial will NOT be responsible for freight OR for onsite labor on components that are removable.** Turn around time of the repair is dependant upon current backlog.

The Warranty Does Not Include The Following: Shear blades • Dies • Die Holder and accessories • Die compensators • Die cushions • Computer controls such as CNC or PLC control for the ram, backgauges or frontgauges or any other computer controlled device • Shear sheet support systems, conveyors, stackers • Or any other purchased accessory items that are not part of the base machine, these items are only subject to their manufacturers warranty.

The 5 year warranty excludes any damages caused by rigging, transportation, and incorrect use or modification by customer or dealer. The user must abide by the maintenance information provided in the service manual that is included with each machine. Maintenance items such as lubrication, bolt tightening, proper leveling of the machine and all other specified actions in the service manual must be adhered to in order for the 5 year warranty to be honored. Second users may be subject to the remainder of the 5 year warranty if they pay for full inspection of the machine by a Standard Industrial rep (contact us for details).

This equipment is manufactured and intended to operate as a component of a complete operating system. The complete system is to include the feeding equipment and/or guards or devices to protect all persons in the vicinity including the operators, depending on the work to be performed. The complete system is the sole responsibility of the owner/operator. The warranty is exclusive and may not be modified by verbal agreement. Other than those representations made expressly in this warranty, we exclude and disclaim all implied warranties of fitness for a particular purpose, and any other implied warranties.

Thousands of machines and Generations of references across the U.S.

QUALITY SERVICE

Professional, readily available service just a phone call away

Onsite training and service technicians available everywhere

Unmatched 5 Year Warranty

based on a 24 hour workday, 7 days a week, 365 days a year

STANDARD INDUSTRIAL CORP

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Clarksdale, MS USA
662.624.2436
www.standard-industrial.com